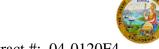
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-019704 Address: 333 Burma Road **Date Inspected:** 29-Jan-2011

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Mr. Xu Le Feng. No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower and Orthotropic Box Girder (OBG)

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10:

Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 500363, Perform Shielded Metal Arc Welding (SMAW) on OBG Traveler rail joint. Joint identified as 20TR2-039-017. ZPMC CWI Identified as Zhao Chen Sun with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F) Repair. For more information see attached picture number 1.

Repair welding, FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040434, Perform Flux Core Arc Welding (FCAW) on OBG Traveler rail joint. Joint identified as 20TR2-039-015. ZPMC CWI Identified as Zhao Chen Sun with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) ESAB-Repair. For more information see attached picture number 2.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Repair welding, FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040434, Perform Flux Core Arc Welding (FCAW) on OBG Traveler rail joint. Joint identified as 20TR2-039-013. ZPMC CWI Identified as Zhao Chen Sun with temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) ESAB-Repair.

Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performing MT on OBG Bike path Stringer plate. Joint identified as BK010A2-001-(030 B). For more information see attached picture number 3.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.







Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

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your project.

Inspected By: Gaikwad, Shailesh Quality Assurance Inspector

Reviewed By: Clifford,William QA Reviewer